

Date: Tuesday, 4/17/2007 3:56:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP (CASTING DETAIL)
Job Number	: 31925		
Estimate Number	: 10510		
P.O. Number	: N/A	Part Number	: D25763
This Issue	: 4/17/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2576 REV. E1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29486	Drawing Revision	: E1
		Material	: N/A
		Due Date	: 5/5/2007
Written By	:	Qty:	100 Um: Each
Checked & Approved By	:		
Comment	: Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D25761	Step (Casting Detail)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
1	D2576-1	Step (Casting Detail)	31940

J.L / J.F. 07/06/13 106

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS1

1- Machine as per Folio FA332 and Dwg D2576

2- Deburr

J.L / J.F. 07/06/13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L / J.F. 07/06/17

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07.06.21

5.0	PACKAGING.1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BARCLAY

07/06/21 (103)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D0576-3 PAR #: N/A Fault Category: Prod / Machine ^{PTS} NCR: (Yes) No DQA: 28 Date: 07/06/22
 QA: N/C Closed: 18 Date: 07.06.22

NCR: <u>31925</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/18	2.0	3 parts are under .125" by 0.003" max at the center Aft welding location. R.C. cap was slightly lifted during machining.	<u>Q51042</u>	Parts acceptable. not Dimensions are not in a critical spot.	J.L. 07/06/19	<u>07/06/18</u>	<u>Q51042</u>	<u>07/06/18</u>
07/06/18	2.0	3 parts scrap. Parts pulled up to much, and have tool marks in them, and dimensions are too thin. .098 → .100.	<u>Q51042</u>	Scrap 3 parts & destroy.	J.L. 07/06/19	<u>07/06/18</u>	<u>Q51042</u>	<u>07/06/18</u>

NOTE: Date & initial all entries

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Drawing Name: STEP (CASTING DETAIL)

Job Number: 31925

Part Number: D25763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



103

Comment: FINAL INSPECTION/W/O RELEASE

207/06/22

Job Completion



U 070622

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

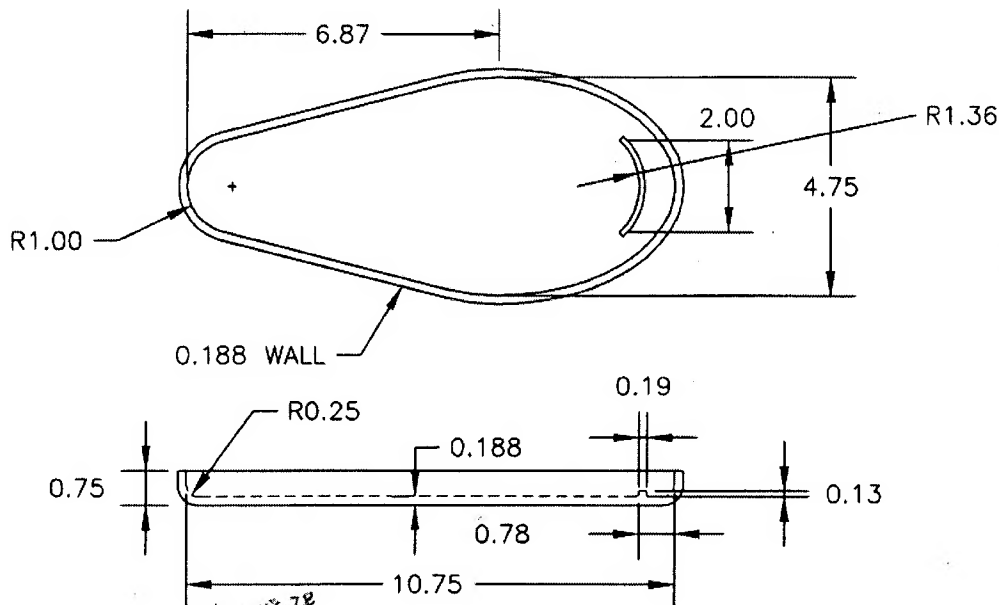


DESIGN 91	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 11	APPROVED KE	DRAWING NO. D2576	REV. E SHEET 1 OF 1
DATE 99.09.07		TITLE STEP	SCALE 1:4
A	96.09.18	NEW ISSUE	
B	96.11.28	REMOVE POCKETS, ADD HOLE	
C	98.08.18	ADD POCKETS & SLOTS FOR WELDING	
D	99.08.18	CHNG. SLOT SIZE AND LOC.(TSR A1069)	
E	99.09.07	CHNG. 0.50 HOLE LOC. AND ADD NOTE	
E1	RF 03.04.29	7.05 WAS 6.61	

RELEASED
99.09.08 DS

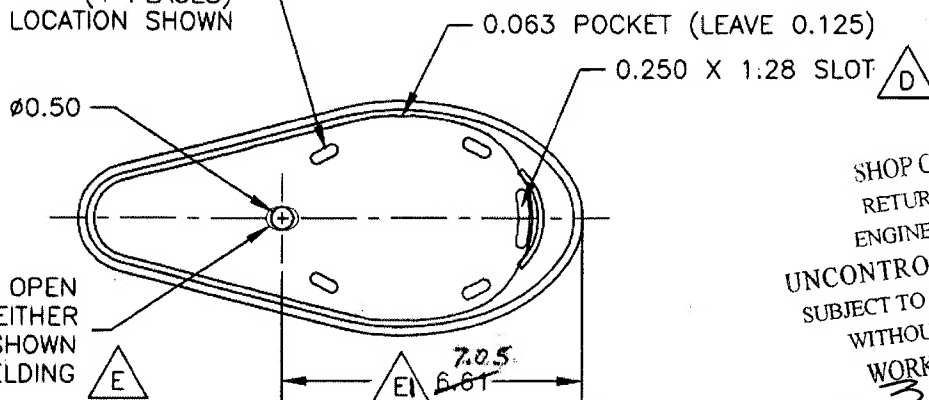
CASTING DETAIL (D2576-1) *#00.08.28*
UP 08.28

MATERIAL: CAST ALUMINUM ALLOY A-535.2
BREAK SHARP EDGES 0.025 TO 0.050
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) *#00.08.28*
UP 08.28

$\triangle D$ 0.250 X 0.65 SLOT
(4 PLACES)
IN APPROX. LOCATION SHOWN



IT IS ACCEPTABLE TO OPEN
THIS HOLE 0.125 IN EITHER
DIRECTION AS SHOWN
FOR WELDING $\triangle E$

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31925